

Date: Wednesday, 11/23/2005 7:17:50 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER ASSEMBLY
Job Number	: 24956C		
Estimate Number	: 10295		
P.O. Number	: N/A	Part Number	: D3220042 041
This Issue	: 11/23/2005 S.O. No. : N/A	Drawing Number	: D3220 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: 23722C	Material	: N/A
Written By	: See Comment below	Due Date	: 12/20/2005 Qty: 5 Um: Each
Checked & Approved By	: See Comment below		
Comment	: Est Rev:A New Issue 05-11-06 JLM		

Additional Product

Job Number:



Machining Operation:

Description :

2024-T3S050

2024-T3 .050 sheet



Comment: Qty.: 0.7266 sf(s)/Unit Total: 3.6330 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.050" thick

M2024T3S.050

Identify for D3220-2

Batch: B19053

2.0

SHEAR

SHEAR



Comment: Cut blank: 14.250" x 7.000" grain along 14.250"

J.L 05-12-20 5

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine D3220-2 as per Folio FA362 and Dwg D3220 Stack of 5

Identify as D3220-2 - 1

J.L 05-12-20 5

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 05-12-20 5

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 05-12-20 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/23/2005 7:17:51 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER ASSEMBLY

Job Number: 24956C

Part Number: D322042 - 041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Debur

2-C'sink D3220-7 as per Dwg D3220

FF 06-01-06

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 06-01-06

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06-01-06

9.0

MS20426AD34

RIVET



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty Part Number

Description Batch

8 MS20426AD3-4

Rivet

M15786

FF 06-01-06

10.0

MS21059L4

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 MS21059L4

Nutplate

M19522

FF 06-01-17

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

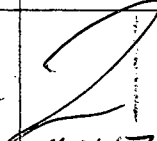


Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3220-042 doubler as per Dwg D3220

FF 06-01-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-01-17	60	Add Qc5 After c'sink permanent change	CE	06.01.17		U 06-01-17	 06-01-17	

Part No: D 3220-041 PAR #: _____ Fault Category: Prod/Small & medium ^{Free ASS} NCR: Yes No DQA: Yes Date: 06/01/18
 QA: N/C Closed: Yes Date: 06.01.18

NCR: <u>24956C</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-01-17	6	Parts c'sunk AS-041. Employee didn't read dwg carefully.		Retrain employee Identify parts A -041 on this w/c.	U 06-01-17	 06-01-17	 06-01-17	 06-01-17

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER ASSEMBLY

Job Number: 24956C

Part Number: D3220042 - 041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



26-01-17

Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

*Identify and Stock
Location: 97*

LC 8/1/17 (5)

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/01/18

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

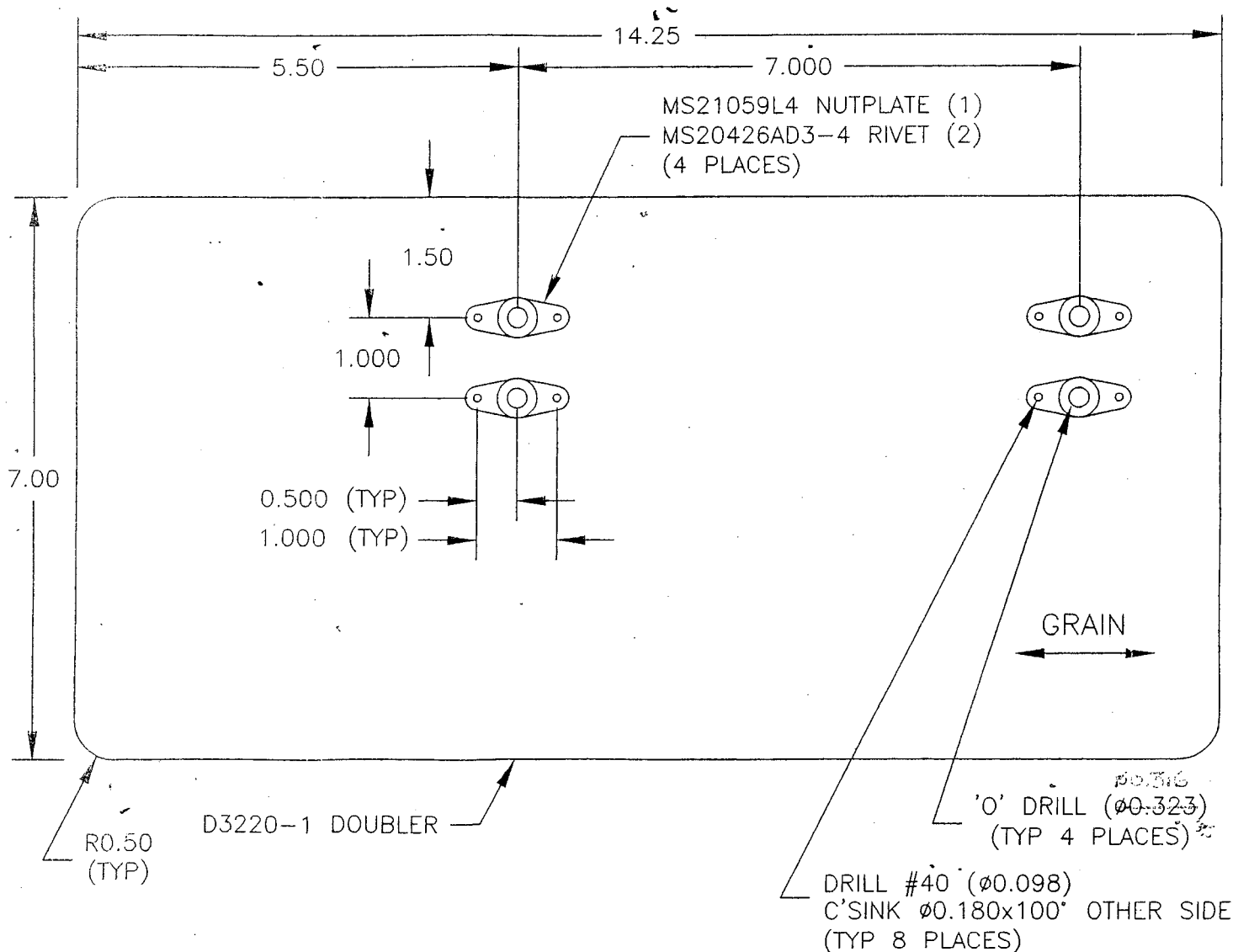
NOTE: Date & initial all entries

PART



DESIGN	<i>HT</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>HT</i>	APPROVED	<i>HT</i>	DRAWING NO. D3220	REV. A SHEET 1 OF 2
DATE	03.10.16			TITLE DOUBLER	SCALE 1:2
A	03.10.16			NEW ISSUE	
A1	<i>CP</i>	<i>HT</i>	03.11.13	CORRECTED DIM	

RELEASED
03.11.14



D3220-041 (SHOWN) / -042 (OPPOSITE) DOUBLER ASSEMBLY (D3220-1 DOUBLER)

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
(REF DART SPEC. M2024T3S.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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